



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.2511

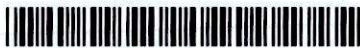
Job Sheet 211954



Part No: 647.2511

Job Qty: 36 pcs

Part Name: Nut



Part Weight: 0 lbs

Job Created: 7/31/20

Due Date: 8/14/20

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG 647.2500 REV.A IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED BY:DD IPP REV:B 19.02.27 AS PER
DWG REV.A DD VERF:JFS

Ship Via:

PRIORITY

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Doosan - 1	36 pcs		8/5/20	1.00	17.15	Doosan - 1		<i>J 20/06/23</i>
110	QC 2	36 pcs		8/5/20	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		<i>J 20/06/23</i>
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



Container No: S295558



Part: 647.2511

Job No: 211954

Serial No/Batch: S295558

Revision: Rev A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 08/23/20

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

140 QC 8	36 pcs	8/5/20	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 2 - 73	
				QC 2 - 69	
				QC 2 - 76	
				QC 2 - 86	
				QC 2 - 83	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	J.C. C. 20-08-23
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
150 Outsource - 17 - Passivate	36 pcs	8/14/20	0.00 0.00	QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
				QC 8 - 57	
				QC 8 - 76	
				QC 8 - 61	
				QC 8 - 66	
				QC 8 - 73	
				QC 8 - 82	
				GRO002-VC	7 J.C. C. 20-08-25
160 Packaging 2-1 - Receive - B4B	36 pcs	8/14/20	0.00 0.00	Packaging 2 - 1 - B4B	
				Packaging 2 - 2 - B4B	
				Packaging 2 - 3 - B4B	
				Packaging 2 - 5 - B4B	
				Packaging 2 - 4 - B4B	
				Packaging 2 - 6 - B4B	
				Packaging 2 - 7 - B4B	
				Packaging 2 - 8 - B4B	
				Packaging 2 - 9 - B4B	
				Packaging 2 - 10 - B4B	
				Packaging 2 - 11 - B4B	
				Packaging 2 - 12 - B4B	
				Packaging 2 - 13 - B4B	
				Packaging 2 - 14 - B4B	
				Packaging 2 - 15 -	

					B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
					Packaging 2 - 20 - B4B	
					Packaging 2 - 21 - B4B	
					Packaging 2 - 22 - B4B	
					Packaging 2 - 23 - B4B	
					Packaging 2 - 24 - B4B	
					Packaging 2 - 25 - B4B	
					Packaging 2 - 26 - B4B	
					Packaging 2 - 27 - B4B	
					Packaging 2 - 28 - B4B	
					Packaging 2 - 29 - B4B	
					Packaging 2 - 30 - B4B	
					Packaging 2 - 31 - B4B	
					Packaging 2 - 32 - B4B	
					Packaging 2 - 33 - B4B	
					Packaging 2 - 34 - B4B	
					Packaging 2 - 35 - B4B	
					Packaging 2 - 36 - B4B	
					Packaging 2 - 37 - B4B	
170	QC 6	36 pcs	8/14/20	0.00 0.00	QC 6 - 9	
					QC 6 - 68	
					QC 6 - 61	DAS
					QC 6 - 40	82
					QC 6 - 81	9-89
					QC 6 - 82	AUG 31 2020
180	Packaging 3-1 - Stock - B4B	36 pcs ✓	8/14/20	0.00 0.00	Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B ✓	DAS
					Packaging 3 - 4 - B4B	SEP 01 2020
					Packaging 3 - 5 - B4B	80
					Packaging 3 - 6 - B4B	9-89
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 -	

				B4B		
				Packaging 3 - 12 - B4B		
				Packaging 3 - 13 - B4B		
				Packaging 3 - 14 - B4B		
				Packaging 3 - 15 - B4B		
				Packaging 3 - 16 - B4B		
				Packaging 3 - 17 - B4B		
				Packaging 3 - 18 - B4B		
				Packaging 3 - 19 - B4B		
				Packaging 3 - 20 - B4B		
				Packaging 3 - 21 - B4B		
				Packaging 3 - 22 - B4B		
				Packaging 3 - 23 - B4B		
				Packaging 3 - 24 - B4B		
				Packaging 3 - 25 - B4B		
				Packaging 3 - 26 - B4B		
				Packaging 3 - 27 - B4B		
				Packaging 3 - 28 - B4B		
				Packaging 3 - 29 - B4B		
				Packaging 3 - 30 - B4B		
				Packaging 3 - 31 - B4B		
				Packaging 3 - 32 - B4B		
				Packaging 3 - 33 - B4B		
				Packaging 3 - 34 - B4B		
				Packaging 3 - 35 - B4B		
				Packaging 3 - 36 - B4B		
				Packaging 3 - 37 - B4B		
190	QC 21 - SA	36 pcs	8/14/20	0.00	0.00	QC 21 - SA - 21 QC 21 - SA - 70 QC 21 - SA - 9 QC 21 - SA - 77
Part Op 100 - (Doosan Lathe) 1- Turn as per Folio FB144 AND DWG DWG Rev: <u>4</u> FOLIO Rev: <u>44</u> -Deburr per dwg Descriptions: ***CHECK THREADS USING GO/ NO GO GAUGE***** 110 - (QC2- Inspect parts off machine FAI/FAIB) 140 - (QC8- Inspect parts - second check) 100% CHECK,CHECK ALL DIMENSIONS AND THREAD FIT 150 - Issue P/O: <u>46954</u> Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required 160 - (Receive & Inspect for Damage & Mat'l Certs) Ensure certificate of conformity is attached 170 - QC6- All purchased or subcontracted products						SEP 01 2020 DAS 70 9-89

180 - (Identify as per dwg & Stock Location: _____)

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M17-4-H1150-R1.000	17-4 SS Round Bar 1.000"	1.8000 ft (.05 ea)	100-Doosan - 1	S285083

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Doosan - 1	M17-4-H1150-R1.000	2	1	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Nut	0.875Inches $\pm$ 0.010	0.885 0.865		
2	Nut	0.530Inches $\pm$ 0.010	0.540 0.520		
3	Nut	90.000Degrees $\pm$ 0.500	90.500 89.500	Angle	
4	Nut	0.660Inches $\pm$ 0.010	0.670 0.650		
5	Nut	0.130Inches $\pm$ 0.010	0.140 0.120		
6	Nut	0.580Inches + 0.000 - 0.002	0.580 0.578		
7	Nut	0.590Inches $\pm$ 0.010	0.600 0.580		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

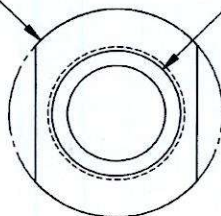
Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread	Other/Details: _____ _____ _____
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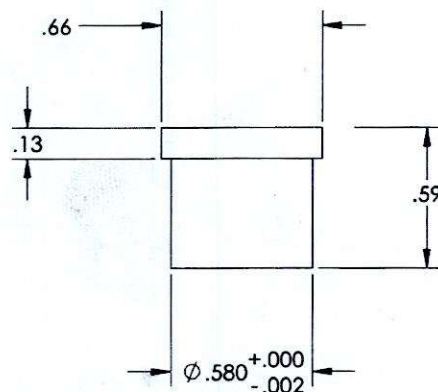
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Ø.401 DRILL & TAP M11 X 1.0 THRU
 ✓ Ø.53 X 90°



647.2511



ORIGINAL DATE 06-04-09		APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300	
DRAWN BY J. GARDNER	CHECKED P. BRAVO		
DRAWING APPROVAL P. BRAVO		SKID SLEEVE	
CONTRACT NO.		REV. A	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°		SIZE B	CAGE CODE 07M26
SCALE: NONE		DWG. NO. 647.2500	SHEET 2 OF 2



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046954



Supplier: GRO002-VC
Group Altech
2455 Halpern
St Laurent
QC
H4S 1N9 Canada
Phone: 514-335-3666
Fax: 514-335-3868

Attention: Grenon, Sylvie

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB046954

PO Date: 8/25/20

Due Date: 9/2/20

**Purchase Order
Revision:**

Revision Date:

Issued By: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 60

Freight Terms:

Special Comments:

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	212077	650.9610	650.9600 REV-PB2	Electric Valve Body -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X6	-	9/2/20	6 pcs	0 pcs	6 pcs	\$0.35/pcs	\$2.10
									AUG 31 2020			
2	210876	651.0101	651.0100 REV.PE2	Angled Gauge Adapter -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 316 stainless steel -Certificate of Conformity is required	Firmed X3	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
									AUG 31 2020			
3	210662	650.7712	650.7700 REV.PF1	Mechanical Cap -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
									AUG 31 2020			
4	211175	650.7810	650.7800 REV.PA1	Pull Rod -Issue P/O; _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed X3	-	9/2/20	3 pcs	0 pcs	3 pcs	\$0.35/pcs	\$1.05
									AUG 31 2020			

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PURCHASE ORDER

POHB046954



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	212002	654.6411	654.6400 REV-PR2	Plug Fitting -Issue P/O: _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed XS	-	9/2/20	5 pcs	0 pcs	5 pcs	\$0.35/pcs	\$1.75
6	212001	654.6412	654.6400 REV-PR2	Fill Piston Fitting -Issue P/O: _____ PASSIVATE IAW QQ-P-35C, TYPE II -Material type; 303 stainless steel -Certificate of Conformity is required	Firmed XS	-	9/2/20	5 pcs	0 pcs	5 pcs	\$0.35/pcs	\$1.75
7	211954	647.2511	647.2500 Rev A	Nut : Various STC's Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed X36	-	9/2/20	36 pcs	0 pcs	36 pcs	\$2.45/pcs	\$88.20
8	211953	647.2510	647.2500 Rev A	Sleeve : Various STC's Issue P/O: _____ Pasivate as per MIL-S-5002 TYPE 6 Certificate of conformaty is required	Firmed X36	-	9/2/20	36 pcs	0 pcs	36 pcs	\$0.88/pcs	\$31.68
Grand Total:												\$128.63

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 8/28/20 4:16 PM Dart.Guerin.Kimberley



Certificat de Conformité / Certificate of Compliance



2455, Rue Halpern | Saint-Laurent | Québec | H4S 1N9
 Tel: 514-335-3666 Fax: 514-335-3868
 www.groupaltech.com

Bon de Livraison / Packing Slip

030554 - 1

Livré à / Ship to

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 Tel.: 613-632-5200 Fax.:

Client / Customer:

DART AEROSPACE LTD
 1270 ABERDEEN STREET
 HAWKESBURY, ON, K6A1K7
 CANADA
 BUYER:

Date expédition Ship date		Créé Par Generated By		Transport / No de Compte Courier / Acc. No.		Bon de commande Client Customer Purchase Order No.			
28-Aug-2020		Ian Wilson				POHB046954			
#Ligne Line#	No. de Série / # Pièce Part Number /Line Item Details Job # / Ref #	Description pièce(s)	CATG. U/M	Comm. /Ordered	Exp/ Shipped	Qté NC/ NC Qty	Qté Scrap/	A venir/ Back Order	
1	650.9610 Rev.	650.9610 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST PASSIVATE IAW QQ-P-35C MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	6	6	0	0	0	
2	651.0101 Rev.	651.0101 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] TEST ONE PART FIRST PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 316 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0	
3	650.7712 Rev.	650.7712 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0	
4	650.7810 Rev.	650.7810 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	3	3	0	0	0	
5	654.6411 Rev.	654.6411 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QQ-P-35C, TYPE II MATERIAL TYPE: 303 STAINLESS STEEL	PASSIVATION CH	5	5	0	0	0	
6	654.6412 Rev.	654.6412 01 -PASSIVATION-DICHROMATE [PASSIVATION BICHROMATE] PASSIVATE IAW QC-P35C, TYPE II MATERIAL TYPE 303 STAINLESS STEEL	PASSIVATION CH	5	5	0	0	0	
7	647.2511 Rev.	647.2511 01 -PASSIVATION DICHROMATE [PASSIVATION DICHROMATE] PASSIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	36	36	0	0	0	
8	647.2510 Rev.	647.2510 01 -PASSIVATION DICHROMATE [PASSIVATION DICHROMATE] PASSIVATE AS PER MIL-S-5002 TYPE 6	PASSIVATION CH	36	36	0	0	0	

DAS
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9-89

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CANADA
BUYER:

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Page 2 of 2